

Date: Tuesday, 4/17/2007 3:56:02 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LITTER DECKPLATE 350
Job Number	: 31918		
Estimate Number	: 10357		
P.O. Number	: <i>N/A</i>	Part Number	: D2344
This Issue	: 4/17/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2344 REV.E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: 29143	Material	: <i>N/A</i>
Written By	: _____	Due Date	: 5/2/2007 Qty: 10 Um: Each
Checked & Approved By	: <i>4/27/07.18</i>		
Comment	: Est Rev:D 00:06.26 Removed P/O for powder coat EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.7823 sf(s)/Unit Total : 7.8225 sf(s)

Material: 2024-T3 QQ-A-250/5) .063

Batch

*M101022 (8)**M102942 (4)**SAD 07/05/18**10*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

*SAD 07/05/18**(10)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/05/18**(10)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*2005-23 (10)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL/MED FAB

1-Deburr sharp edges

2-Countersink holes per Dwg D2344

*m107/05/18**X10**(P10)*

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*2005-28 (6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: R Date: 07/15/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/28	5.0	Up parts scrap. C'sink is way too deep, due to C'sink dimension on the dwg.	QS1042	destroy scrap parts. See PAR for C'sink size change. PAR 181	07/05/28	07/05/28	QS1042	07/05/28

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:56:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER DECKPLATE 350

Job Number: 31918

Part Number: D2344

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HS

07-05-29

(6)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m 1023/6

bl/a.m

07/05/30

(6)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/5/31

(6) 59

10

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Identify and Stock

Location: SF222

7/5/31

50/6

(6)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/31

(6)

Job Completion



11 07-05-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	31918
<b>Description:</b> Litter Deck Plate Kit (350)		<b>Part Number:</b>	D2344
<b>Inspection Dwg:</b> D2344 <b>Rev:</b> E		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

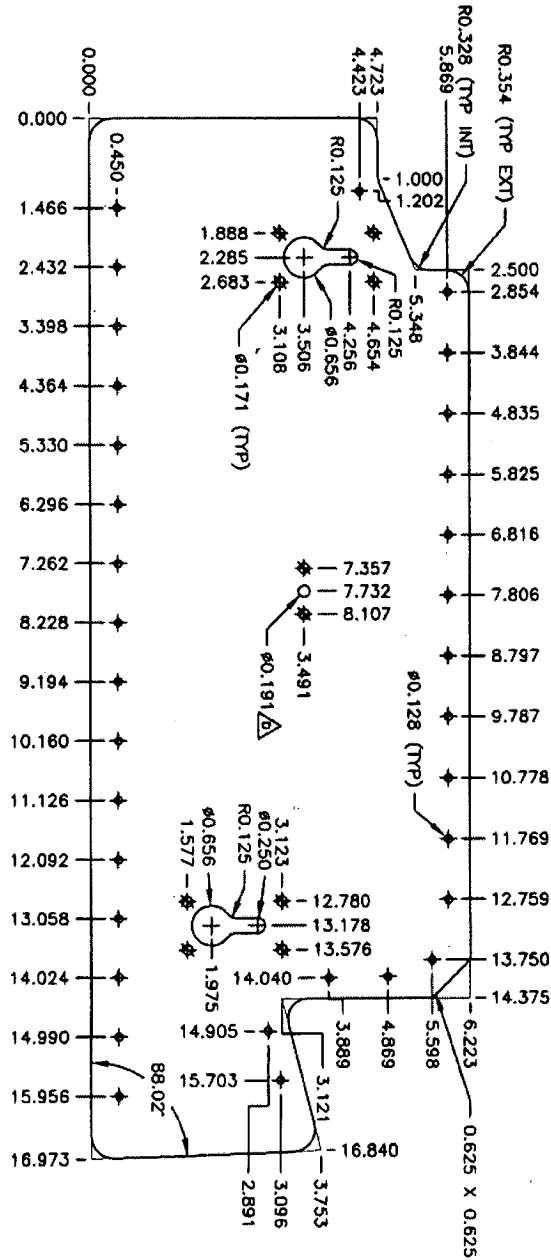
☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<del>0.991</del>	<del>+/-0.005</del>					
6.223	+/-0.010	6.228	✓		Vern	
5.598	+/-0.010	5.593	✓		Vern	
4.869	+/-0.010	4.872	✓		Vern	
3.889	+/-0.010	3.891	✓		Vern	
3.096	+/-0.010	3.100	✓		Vern	
2.891	+/-0.010	2.891	✓		Vern	
N/A NA <del>16.973</del>	<del>+/-0.010</del>	N/A				CE
<del>0.966</del>	<del>+/-0.005</del>	N/A				CE
0.450	+/-0.010	0.450	✓		Vern	
4.423	+/-0.010	4.422	✓		Vern	
4.723	+/-0.010	4.720	✓		Vern	
1.202	+/-0.010	1.202	✓		Vern	
5.869	+/-0.010	5.869			Vern	
4.654	+/-0.010	4.653	✓		Vern	
Ø0.656	+0.005/-0.000	Ø0.656	✓		Vern	
1.888	+/-0.010	1.890	✓		Vern	
2.285	+/-0.010	2.290	✓		Vern	
2.683	+/-0.010	2.690	✓		Vern	
Ø0.171	+0.005/-0.000	Ø0.173	✓		Vern	
<del>0.750</del>	<del>+/-0.005</del>					CE
3.491	+/-0.010	3.495	✓		Vern	
Ø0.191	+0.005/-0.000	Ø0.192	✓		Vern	
N/A E <del>0.796</del>	<del>+/-0.005</del>					CE
<del>3.128</del>	<del>+/-0.010</del>					CE
<del>1.527</del>	<del>+/-0.010</del>					CE
1.975	+/-0.010	1.980	✓		Vern	
Ø0.128	+0.005/-0.000	Ø0.131			Vern	CE
<b>Measured by:</b> SAD	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>		N/A		
<b>Date:</b> 07/05/18	<b>Date:</b> 07-05-23	<b>Date:</b>		N/A		

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	[Signature]

NO. 31918  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
CONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
MA  
FIN TO

COUNTER SINK HOLES:  
 \* SINK Ø0.225 x 100°  
 \* SINK Ø0.300 x 100°  
 = Ø0.285 x 100° 407.05.28



DESIGN	KE	APPROVED	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWING NO. D2344	DATE 98.06.19
DRAWN BY	KE	APPROVED	KE	REV. E SHEET 1 OF 1	TITLE LITTER DECK PLATE, 350	SCALE 1:3
A	95.01.14	NEW ISSUE	B	95.02.09	MOVED KEY HOLES	D
B	95.03.06	0.191 WAS 0.197	E	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	

RELEASED 1/8/06/22 KE

**DART**